

Work Order ID 64702



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Item ID: D350-578-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 12/14/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 12/14/10 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-578-011 CHG005

8/11/10

CK Pa BG 11/1/10

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/1/10 SP 50

170

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

8/11/10

85

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D350-578-011

Accept

Revision ID:

Item Name: Bearpaw

Start Date: 12/14/2010 Start Qty: 5.00

Required Date: 12/22/2010 Req'd Qty: 5.00

Reference:



Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 	Packaging	0.00				11/1/10	SP		(52)
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D350-578-011 Location: <u>A</u> <u>Reco A</u>								
190 	QC21- Final Inspection - Work Order Release	0.00				EX	11/01/10		
QC	Memo	0.00							
Quality Control									

MF

11-01-10

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Picklist Print

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Work Order ID: 64702

Parent Item: D350-578-011

Parent Item Name: Bearpaw.



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:A New Issue 07-01-02 JLM
IPP Rev:B 08-01-09 Added Step 2 JLM Verified By:EC
IPP Rev:C 08-10-15 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN4-17A		Purchased	No			160	Each	118.0000	12	60			
+ Bolt													

Location Loc Qty Loc Code

ST358 100

116400 100

ST359 18

112314 18

D2182B		Manufactured	No			160	f	238.9960	2.5	12.5			
Rubber Cushion													

Location Loc Qty Loc Code

ST410 238.996

63413 238.996

D2274		Manufactured	No			160	Each	25.0000	12	60			
Radius Block													

Location Loc Qty Loc Code

ST010 25

61361 1

63990 24

D2432		Manufactured	No			160	Each	0.0000	2	10			
206 (24") Bearpaw													

11/1/10

50

10

11/1/10

✓

B64420 11/1/10

64701 11/1/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr.	Approval QC Inspector

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Work Order ID: 64702

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

D2438

Manufactured No

160 Each

3.0000

6 30



Clamp



B63999 12/14/10

Location

Loc Qty

Loc Code

ST456

3

60852

3

D2529

Manufactured No

160 Each

927.0000

12 60



Washer



12/14/10

Location

Loc Qty

Loc Code

ST017

927

64127

927

MS21042L4

Purchased No

160 Each

4,634.000

12 60



Nut



12/14/10 SP SE

Location

Loc Qty

Loc Code

ST300

4634

1123143

2

115589

32

115621

1100

116188

3500

60

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 64702

Parent Item: D350-578-011

Parent Item Name: Bearpaw



Start Date: 12/14/2010

Required Date: 12/22/2010

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

160

Each

4,182.000

24

120



Washer



12/14/10

50

Location

Loc Qty

Loc Code

ST297

2800

116304

2800

ST298

1382

110914

4

115622

38

116025

118

116289

1222

120

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Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

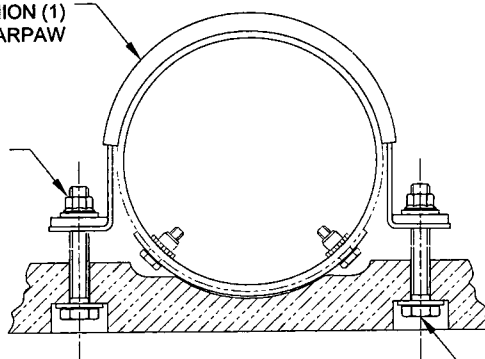
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NOTE: Date & initial all entries

D2438 CLAMP (1)
D2182B050 RUBBER CUSHION (1)
3 PL PER BEARPAW

MS21042L4 NUT (1)
AN960JD416 WASHER (1)
D2274 RADIUS BLOCK (1)
D2529 WASHER (1)
AN4-17A BOLT (1)
6 PL PER BEARPAW



ADDITIONAL AN960JD416 WASHERS MAY BE INSTALLED UNDER THE NUTS TO ENSURE 1.5-4 THREADS IN SAFETY ON THE BOLTS. ALTHOUGH NOT GENERALLY NECESSARY, IT IS ALSO ACCEPTABLE TO REPLACE THE AN4 BOLTS PROVIDED WITH LONGER OR SHORTER AN4 BOLTS, IF REQUIRED.

Section A-A
Figure 4 - Clamping Detail

5.0 PARTS LIST

Qty -011	Qty -021	Part Number	Description
X		D350-578-011	BEARPAW INSTALLATION
	X	D350-578-021	BEARPAW INSTALLATION
6	6	D2182B050	Rubber Cushion
12	12	D2274	Radius Block
12	12	D2529	Washer
6	6	D2438	Clamp
2		D2432F	Bearpaw
	2	D2672F	Bearpaw
12	12	AN4-17A	Bolt
24	24	AN960JD416	Washer
12	12	MS21042L4	Nut (or MS21042-4)